

TITLE OF THE INVENTION

Inorganic Composition, Process of Preparation
and Method of Use

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CROSS-REFERENCE TO RELATED APPLICATIONS

This application claims priority on United States Provisional Patent Application Serial Nos. 60/104,203 and 60/082,448 which were filed on October 14, 1998 and April 20, 1998, respectively.

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BACKGROUND OF THE INVENTION

The present invention relates generally to coagulants for water treatment applications. In general, coagulants are utilized to remove suspended solid particles from aqueous systems.

15 Coagulants typically fall into the general category of inorganic (trivalent, divalent metal salts) or organic (water soluble polyelectrolytes). Examples of widely used inorganic coagulants are aluminum sulfate $\text{Al}_2(\text{SO}_4)_3$, aluminum chloride AlCl_3 , aluminum chlorohydrate $\text{Al}_2(\text{OH})_5\text{Cl}$, ferric chloride FeCl_3 , ferric sulfate $\text{Fe}_2(\text{SO}_4)_3$, and calcium chloride. Examples of commonly used water soluble or solution polyelectrolytes are p-DMDAAC (polydimethyl diallyl ammonium chloride) and
20 Epi-DMA polyamine.

Many inorganic coagulants are compatible with solution cationic polyelectrolytes and can be combined to form stable combinations. In recent years, many different blend formulations of an inorganic coagulant with a high charge solution cationic polyelectrolyte have been patented and

marketed. An example of an inorganic coagulant/polymer blend might be: 5 parts of a standard 28° Baumé AlCl_3 solution mixed with 1 part of Epi-DMA polyamine. More examples, limits, and ranges are explained in United States Patent Nos. 4,746,457, 4,800,039, and 5,035,808 to Calgon Corporation, and further in United States Patent Nos. 2,862,880, 3,285,849, 3,472,767, 3,489,681, 5 3,617,569, 4,137,165, 4,450,092, 4,582,627, 4,610,801, and 4,655,934, the disclosures of which are incorporated herein by reference in their entirety. Normally, these compositions are physical blends of an inorganic trivalent metal salt solution and a water soluble polymer solution, which is a simple mixture of the components where both components retain their original identity or chemical composition, but provide utility and advantages such as:

- 10 1. a synergy of adding the inorganic and polymeric coagulants simultaneously as a blend; and
2. ease of use – using one product instead of two (thereby eliminating feed systems, equipment, and handling).

Wastewater treatment systems typically require the use of trivalent metal salts, a polymer or 15 a combination of both in the coagulation process. Both ferric coagulants such as FeCl_3 blends and aluminum coagulants such as alum or $\text{Al}_2(\text{OH})_5\text{Cl}$ blends are often used for these processes. Both the ferric and aluminum coagulants provide different desirable properties. However, these coagulants are normally incompatible with each other.

It was thus desired in the art to develop a single coagulant which would combine the 20 desirable properties of ferric and aluminum coagulants.

SUMMARY OF THE INVENTION

The present invention comprises a composition that is the reaction product of a trivalent metal salt, excluding chromium salts, an acid phosphorous compound and an aluminum hydroxy chloride, and a process for preparing the same.

5 The method of use according to the present invention comprises adding this reaction product in an effective amount to the solution to be treated. The composition of the present invention is an excellent and unique coagulant for most water treatment applications.

As used herein, the phrase "effective amount" refers to that amount of the claimed reaction product which is helpful to at least partially treat (coagulate) the impurities in the wastewater or
10 system being treated.

BRIEF DESCRIPTION OF THE DRAWINGS

The above composition will become more apparent when reference is made to the following detailed description, taken in conjunction with the appended figures, in which:

15 FIG. 1 is an Al-27 NMR spectrum of monoaluminum phosphate;
FIG. 2 is an Al-27 NMR spectrum of aluminum chlorohydrate; and
FIG. 3 is an Al-27 NMR spectrum of the reaction mixture of iron (III) chloride,
monoaluminum phosphate and aluminum chlorohydrate.

These figures are discussed in detail below.

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DETAILED DESCRIPTION OF THE INVENTION

The present invention was discovered when the inventors were attempting to obtain the desirable properties of FeCl_3 blends and $\text{Al}(\text{OH})_3\text{Cl}$ blends by mixing these two inorganics and then

combining the resultant mixture with a cationic polyelectrolyte and other ingredients. However, they discovered that mixtures of trivalent metal salts such as FeCl_3 and aluminum hydroxy chlorides such as $\text{Al}_2(\text{OH})_5\text{Cl}$ are incompatible and all attempts to combine such mixtures ended in a gelled/solidified reaction product which was not usable.

5 It was unexpectedly discovered that FeCl_3 solution and $\text{Al}_2(\text{OH})_5\text{Cl}$ solution can be stabilized and combined through the use of a third ingredient, monoaluminum phosphate. The inventors have discovered a method of combining these previously incompatible coagulants and creating a stable, complex ion coordination compound that exhibits increased efficacy as a coagulant for industrial and municipal water treatment.

10 A composition, and process for preparing the same, has been discovered by the inventors comprising the reaction product of a trivalent metal salt other than chromium salts, an aluminum hydroxy chloride, and an acid phosphorous compound which acts as a stabilizing compound.

The preferred process of preparing the present invention is the addition of the acid phosphorous compound (stabilizer) to the trivalent metal salt, soon followed by the addition of the
15 aluminum hydroxy chloride. A small exotherm results from the addition of the acid phosphorous compound (stabilizer) to the trivalent metal salt. A larger and more vigorous exotherm results from the subsequent addition of the aluminum hydroxy chloride. Based upon this exotherm, as well as color changes and partial precipitation (and re-dissolution), it is believed that the components are reacting and a new compound is formed. Although the order of addition of these compounds to form
20 the new compound may be altered, the above order of addition is preferred. If the trivalent metal salt and the aluminum hydroxy chloride are combined without the acid phosphorous compound, a slurry will be formed which will generally solidify in less than an hour. In order to create a stable final product, if this order of addition is utilized, the acid phosphorous compound should be added to this

mixture prior to solidification, or preferably within 40 minutes. However, reconstitution after solidification is possible by the addition of the acid phosphorous compound. The least preferred order of addition is when the acid phosphorous compound is alone first mixed with the aluminum hydroxy chloride, because a solid mass will be formed almost instantaneously. However, this solid mass can be reconstituted by the addition of FeCl_3 . For these reasons, the above noted order of addition is preferred.

This new resultant compound is stable and appears to be different in composition from the compounds used in the preparation process. The conclusion that a new compound is formed is supported by Figures 1-3 which illustrate Al-27 NMR spectra for a compound formed from the reaction of the volume formula 10 FeCl_3 (about 40% active raw material in water), 3 monoaluminum phosphate ($\text{Al}(\text{H}_2\text{PO}_4)_3 \cdot \text{XH}_2\text{O}$) (about 50 wt% in water), and 5 $\text{Al}(\text{OH})_5\text{Cl}$ (about 50 wt% in water). Commercially available FeCl_3 solution is 38 to 42% active raw material in water. Commercially available monoaluminum phosphate and $\text{Al}(\text{OH})_5\text{Cl}$ are both 50 wt% in water, plus or minus 1 to 2%.

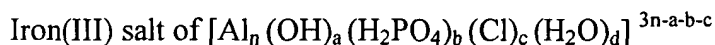
The combination of a peak's shape and position yield structural information in NMR spectroscopy. The position is based upon a relative marker to a selected standard material and is measured in ppm shifts in frequency. The standard reference material used in these spectra was aluminum oxide (Al_2O_3) at 0 ppm. The shape of the peak (singlet, doublet, etc.) is dependent upon the nuclei's interaction with neighboring atoms. The combination of peak position and shape is a function of the nuclei's environment, and thus, its structure.

Figure 1 is an Al-27 NMR spectrum of monoaluminum phosphate. This spectrum shows a single band centered at ca. -77.7 ppm relative to the standard. The width of the peak is indicative of the structure in solution.

Figure 2 is an Al-27 NMR spectrum of aluminum chlorohydrate ($\text{Al}_2(\text{OH})_5\text{Cl}$). This spectrum shows a very broad set of peaks centered at ca. -57.8 and -68.6 ppm with the former peak being the much stronger band. This spectrum shows two peaks which are overlapped. There are also two significantly smaller peaks on either side of these two major bands which are probably minor impurities. This material is known to be polymeric in nature. In general, the higher the molecular weight of a material the more broad the peaks become.

Figure 3 is an Al-27 NMR spectrum of the reaction mixture of the present invention. This spectrum shows the product of the claimed reaction mixture of iron (III) chloride, monoaluminum phosphate and aluminum chlorohydrate according to the current reaction, using the concentrations and parts per volume of these three compounds in the preferred embodiment. In Figure 3, the aluminum NMR peak is a very much sharper singlet and is shifted to a position at ca. -26.2 ppm relative to the standard. These changes indicate that a reaction has taken place, that the two component raw materials (iron(III) chloride and aluminum chlorohydrate) are most likely limiting reagents in this reaction, and that the structure of the final product is simpler than the aluminum chlorohydrate precursor. The aluminum exists in a single type of chemical environment, hence the rationale for the proposed structure of a new compound.

The molecular formula of this preferred embodiment, which is the subject of Figure 3 is:



where $a+b+c > 3n$

This new composition is the product of a Lewis/Acid Base type reaction in which a stable, complex ion coordination compound is formed as follows:

A + B → "intermediate" (4° C. temperature rise observed) "intermediate" + C → new compound (20°

C. temperature rise observed)

where:

(% Active Basis)

5	A=	Iron Chloride	17.5% - 20%
	B=	Phosphoric Acid, Aluminum Slat (3 : 1)	8% - 10%
	C=	Aluminum Chloride, Basic	11.0% - 13%

A typical structure of this new compound of the preferred embodiment is represented below

where the H₂O, Cl, OH and H₂PO₄ ligands can vary in number, as well as in their position on the

10 metal ion in the coordination complex. The nature of the bond between each ligand and the central metal atom is coordinate covalent.

15

The preferred embodiment of the present invention composition, by volume, is:

20	10	FeCl ₃ (aqueous solution about 40% active raw material in water)
	3	Monoaluminum phosphate (Al (H ₂ PO ₄) ₃ • XH ₂ O) (about 50 wt% in water)
	5	Al ₂ (OH) ₅ Cl (about 50 wt% in water)
	1	CaCl ₂ (30% solution)
	2	Ca-250 (Epi-DMA polyamine) (50 wt% in water)

25 Multiple experiments involving the modification of the volume of the above ingredients in the preferred embodiment have been performed. It has been determined that although the above noted volumes provide the preferred combination, these ratios may be altered while still maintaining a stable reaction product and the desired coagulation properties to varying degrees. It has been

determined that (using the concentrations set forth above) the volume of the FeCl_3 component may be varied from 3 to 30 parts, the monoaluminum phosphate may be varied from .5 to 10 parts, and the $\text{Al}_2(\text{OH})_5\text{Cl}$ may be increased to as high as 20 parts. However, the upper limit of the $\text{Al}_2(\text{OH})_5\text{Cl}$ volume appears to be 20 because precipitation begins to occur at this level. Although the quality of the resultant compounds varied proportionally with the deviation from the preferred embodiment, the resultant compounds provided stable reaction products. Further tests have performed varying the combinations of different trivalent metal salts, acid phosphorous compounds and aluminum hydroxy chlorides, as well as the volumes of each such component. The Example below demonstrates the results of selected tests on volume and component variations.

The volumetric ratios set forth above for components of the preferred embodiment are also applicable to the various claimed combinations of the other trivalent metal salts, acid phosphorous compounds and aluminum hydroxy chlorides. It is known by one skilled in the art that these various compounds can be obtained in varying concentrations. In order to obtain the most preferred ratio of components of various substitute components of varying concentration, one must obtain the same ratio of molar amounts of ferric, phosphate or phosphite and aluminum as that of the preferred embodiment above. For example, phosphoric acid is commercially available in about 85 wt% in water as compared to about 50 wt% of monoaluminum phosphate. Thus a component of different concentration can be used if the correct molar ratio is obtained.

It appears that the calcium chloride and CA-250 components are present only as physical blend with the compound which is the result of the reaction. The resulting blend of the reaction product and the CaCl_2 and CA-250 (Epi-DMA polyamine) is a "sweep-floc" which functions as a coagulant and a flocculent and, as noted above, could be useful in many water treatment processes. Other standard additives can also be mixed with the reaction product.

In place of the CA-250 (Epi-DMA polyamine), p-DMDAC may be utilized under certain circumstances in the physical blend with the subject reaction product. The p-DMDAAC may be utilized when the trivalent metal salt FeCl_3 (in the preferred embodiment) is diluted by 10 to 40% with water prior to the addition of the acid phosphorous compound and the aluminum hydroxy chloride. In order to utilize p-DMDAAC with the already prepared reaction product of the preferred embodiment, the entire reaction product must be diluted by 10 to 40% with water prior to the addition of p-DMDAAC. If phosphoric acid is substituted for the monoaluminum phosphate of the preferred embodiment, dilution of either FeCl_3 or the entire reaction product should be by 10 to 80% with water, otherwise precipitation will occur.

Tests have also been performed involving the variance of the amounts of CaCl_2 and the amount of the CA-250 (Epi-DMA polyamine). The volumes of these compounds have been varied both together and on an independent basis. The variance of these two components appears to have a negligible effect on the formulation.

As noted above, although the preferred embodiment utilizes FeCl_3 as the trivalent metal salt, monoaluminum phosphate as the acid phosphorous compound, and $\text{Al}_2(\text{OH})_5\text{Cl}$ as the aluminum hydroxy chloride, substitutions may be made for each of these compounds while still resulting in a stable, effective reaction product.

The preferred trivalent metal salts are those of Group 8. The more preferred trivalent metal salts are metal halides. However, the most preferred trivalent metal salts are ferric, such as FeCl_3 , $\text{Fe}_2(\text{SO}_4)_3$, FeBr_3 and $\text{Fe}(\text{NO}_3)_3$. Additionally, blends of the foregoing may be utilized. Ferric halide is more preferred, while ferric chloride is most preferred. The preferred anions of the salt are chloride and halide. Sulfate is a less preferred anion of the salt. Nitrate may also be employed as an anion for the salt.

circumstance, a reaction product is not formed and a blend is achieved. Nevertheless, this blend exhibits good coagulation properties.

Experiments have also been performed where the CaCl_2 compound has been substituted with MgCl_2 and BaCl_2 without resulting serious detriment to the performance of the resultant mixture with the reaction product. The CA-250 (Epi-DMA polyamine) may also be substituted with other Epi-DMA polyamines. CA-250 is preferred because of its relative low to medium molecular weight. CA-250 is a commercial polyamine product sold by Calgon Corporation.

This resultant new compound has been demonstrated to be an excellent and unique coagulant for most water treatment applications including E-coat waste treatment, water-borne paint waste coagulation, oily waste and solvent-borne paint detackification. It is also exhibits utility in general wastewater treatment, municipal wastewater treatment, metals removal from water, paper making waste water, water containing chemical compounds, water containing organic compounds, water containing biological compounds, poultry processing waste, ink containing solutions, raw water clarification (such as municipal drinking water and industrial purification), oil/water separation, water containing suspended solids, color removal (colored solutions), waste clay slurry, coal waste, mineral processing water, oily waste, water containing suspended solids, water containing paint solids and others. The resultant new compound has also been demonstrated to remove metals from water, including heavy metals such as lead and nickel. E-coat waste is the wastewater generated from electrolytic primer coating.

The method of using the new compound for coagulation in these various systems consists of adding the new compound to the system in an effective amount.

This new compound also may be utilized for enhanced coagulation. Enhanced coagulation is the reduction of total organic contaminants (TOC). The reduction of organic contaminants in

drinking water is desirable to minimize formation of chlorinated hydrocarbons formed during the chlorination process.

The most preferred method for producing the claimed reaction product entails the following steps:

5 1. At ambient temperature, add 3 parts by volume monoaluminum phosphate solution (about 50 wt% in water) to 10 parts by volume FeCl_3 aqueous solution (about 40% active raw material in water). During the addition of the monoaluminum phosphate solution to the FeCl_3 solution, some reaction will take place. There may be some partial precipitations and color changes – and striations in the solutions. However, when the reaction is complete, everything is in solution and it appears stable.

10 2. Next, the 5 parts by volume aluminum chlorohydrate solution (about 50 wt% in water) is added to the mixture of FeCl_3 and monoaluminum phosphate (and further reaction takes place). The resultant solution goes through a violent exotherm. The solution becomes hot, and the solution becomes homogeneous. When the solution cools down, it remains compatible and

15 homogeneous.

 3. Preferably, 1 part by volume CaCl_2 (30% solution) and 2 parts per volume of a polymer, such as CA-250 (EPI-DMA polyamine 50 wt%) are then added. The CaCl_2 is added for hardness and the polymer to enhance coagulation and to begin flocculation (to help form the pin floc). There appears to be no further reaction when the CaCl_2 and the polymer are added.

20 As noted above, it will be apparent to one skilled in the art that this process may be duplicated utilizing the other trivalent metal salts, acid phosphorous compounds, and aluminum hydroxy chlorides herein claimed, if the same noted molar ratios are utilized.

EXAMPLE

The following example is included to further describe and demonstrate the invention in greater detail. This example is not intended to limit the scope of the invention in any way. This example, and the tables included therein, demonstrate the performance of the claimed invention, including the preferred embodiment and other claimed reaction products formed from various Group 8 trivalent metal salts, acid phosphorous compounds and aluminum hydroxy chloride components, on the treatment of E-coat waste. Also included are entries illustrating the effectiveness of treating E-coat waste with only a trivalent metal salt and only an aluminum hydroxy compound.

The following test procedure was used to compile the results contained in the following tables.

Dilution of Product:

1. 2.5 gms of the selected coagulant and/or reaction product was weighed and placed into a B-cup.
2. 7.5 gms of deionized water was placed into the same B-cup and mixed until uniform.

Test Procedure:

1. 495 mls of deionized water was added to a glass jar (a graduated cylinder was used).
2. The glass jar was placed on a gang stirrer and mixed at 100 rpm.
3. 5 mls of neat E-coat waste was added to the water.
4. 0.6 mls of the selected coagulant and/or reaction product solution (300 ppm) was added to the glass jar.
5. The solution was mixed at 100 rpm for 15 seconds.
6. The pH was lowered to 2.9 using stock H_2SO_4 (10gm H_2SO_4 + 190 gm DiH_2O).

7. The number of drops of stock H_2SO_4 used to lower the pH was recorded.
8. The solution was mixed at 100 rpm for 15 seconds.
9. The pH was increased to 8.5 using a soda ash solution (20 gm soda ash + 80 gm DiH_2O).
- 5 10. The number of drops of soda ash solution used to increase the pH was recorded.
11. The solution was mixed at 100 rpm for 15 seconds.
12. 2 mls of flocculent – Pol EZ 8736 or Pol EZ 7736 [0.5% product] which are commercially available high molecular weight polymers sold by Calgon Corporation – was placed in a syringe and added by the following method:
 - 10 a) the tip of the syringe was placed below the surface of the solution at approximately the top of the vortex;
 - b) the flocculent was added and timed for exactly 10 seconds;
 - c) after the ten second period ended, the agitation was turned down to 50-60 rpm;
 - 15 d) the floc was allowed to develop for 30 seconds; and
 - e) the agitation was then turned off.
13. The floc was then allowed to settle for 10 minutes.
14. The floc size and the appearance of the solution was then recorded (visual inspection only).
- 20 15. 20 mls of the solution was removed with a syringe for a turbidity reading.
16. The turbidity reading in NTU (nephelometric turbidity units) was recorded.
17. The agitation was then turned on and the motion speed was slowly increased to ≤ 50 rpm.

18. The solution was mixed for 30 seconds and the percentage of detackification was recorded.

19. The motor speed was then increased to 100 rpm and the solution was mixed for 30 seconds.

5 20. The percentage of detackification was then recorded (if detackification of 100% was recorded at 50 rpm, no reading was necessary at 100 rpm and therefore was not taken).

Unless otherwise noted, this procedure was utilized to obtain the results set forth in the tables below. Flocculation refers to the settling of suspended solid particles in the solution. Turbidity as used herein is defined as the cloudiness of the solution caused by suspended particles.

TABLE 1

This table illustrates the performance of the preferred embodiment, 10 FeCl₃,
3 (Al (H₂PO₄)₃ • XH₂O) and 5 Al₂ (OH)₅Cl, 1 CaCl₂ and 2 Ca-250, in the concentrations set
forth above, as 3930-93. In 3982-84A, the (Al (H₂PO₄)₃ • XH₂O) was substituted with
HEDP in the same molar ratio. In 3982-86A and 3982-87, the (Al (H₂PO₄)₃ • XH₂O) has
been likewise substituted with vinyl phosphonic acid and dimethyl phosphite, respectively.

TABLE 1

	3930-93	3982-84a	3982-86a	3982-87
Description	Preferred embodiment	HEDP	Vinyl Phosphonic acid	Dimethyl Phosphite
Product Dilution (Deionized water/product)	7.5gms/ 2.5 gms	7.5gms/ 2.5 gms	7.5gms/ 2.5 gms	7.5gms/ 2.5 gms
Appearance	medium amber	med.-dk amber	yellow	very pale blue
Use Concentration (mls/ppm)	0.60 mls/ 300 ppm	0.60 mls/ 300 ppm	0.60 mls/ 300 ppm	0.60 mls/ 300 ppm
E-coat Composition	495 mls/ 5mls	495 mls/ 5mls	495 mls/ 5mls	495 mls/ 5mls
pH to 2.9	30 drops	29 drops	34 drops	31 drops
pH to 8.5	45 drops	50 drops	52 drops	40 drops
Floc size/appearance	large/hazy	med. fluffy/ sl. haze	large/lt. haze	med.-lg./sl. haze
Turbidity	93.3	54.2	39.6	72.4
Detackification 50 rpm: 100 rpm	good 100 %	fair 50% 100%	fair-good 65% 100%	bad 0% 60%

TABLE 2

This table likewise illustrates how the performance of the preferred embodiment is effected by changes in the type and amount of the acid phosphorous compound utilized. The composition of the preferred embodiment remained constant for each trial, except: in 3982-79A, a lower volume of $(\text{Al}(\text{H}_2\text{PO}_4)_3 \cdot \text{XH}_2\text{O})$ ("MAP") was utilized; in 3982-79B, a lower volume of H_3PO_4 was substituted for the MAP; in 3982-79C, H_3PO_4 was substituted for the MAP in the same volume; and in 3982-80G, NaH_2PO_4 was substituted for the MAP in the same volume.

TABLE 2

	3930-93	3982-79A	3982-79B	3982-79C	3982-80A	3982-80G
Description	Preferred embodiment	Low MAP	Low H_3PO_4	Std H_3PO_4	Std H_3PO_3	Std NAH_2PO_4
Product Dilution (Deionized water/product)	7.5gms/2.5gms	7.5gms/2.5gms	7.5gms/2.5gms	7.5gms/2.5gms	7.5gms/2.5gms	7.5gms/2.5gms
Appearance	good/med. amber	good/dk. amber	good/dk. amber	good/yellow	good/dk. amber	good/dk. amber
Use Concentration (mls/ppm)	0.60 mls/300 ppm	0.60 mls/300 ppm	0.60 mls/300 ppm	0.60 mls/300 ppm	0.60 mls/300 ppm	0.60 mls/300 ppm
E-coat Composition Deionized water/e-coat waste	495 mls/5mls	495 mls/5mls	495 mls/5mls	495 mls/5mls	495 mls/5mls	495 mls/5mls
pH to 2.9	27 drops	25 drops	24 drops	25 drops	23 drops	24 drops
pH to 8.5	60 drops	60 drops	60 drops	60 drops	60 drops	60 drops
Floc size/appearance	very lg./sl. haze	lg.-tight/very sl. haze	very lg./hazy	lg. loose/sl. haze	med. loose/almost clear	lg. loose/sl. haze
Turbidity	90/88	67	72	68	31	44.7
Detackification 50 rpm: 100 rpm:	good 90% 100%	good 100%	good 100%	good 100%	good 90% 100%	good 100%

TABLE 3

Tables 3 and 4 illustrate the effect of altering the use concentration of the preferred embodiment. The numbers included under the heading "Description" refer to the volumes 10 FeCl_3 , 3 $(\text{Al}(\text{H}_2\text{PO}_4)_3 \cdot \text{XH}_2\text{O})$, 5 $\text{Al}_2(\text{OH})_5\text{Cl}$, 1 CaCl_2 and 2 Ca-250, of the component concentrations of each set forth above.

5

TABLE 3

	#1	#2	#3	#4	#5	#6
Description	Preferred Embodiment 10+3+5+1+2	Preferred Embodiment 10+3+5+1+2	Preferred Embodiment 10+3+5+1+2	Preferred Embodiment 10+3+5+1+2	Preferred Embodiment 10+3+5+1+2	Preferred Embodiment 10+3+5+1+2
Product Dilution Deionized water/product	7.5gms/ 2.5gms	7.5gms/ 2.5gms	7.5gms/ 2.5gms	7.5gms/ 2.5gms	7.5gms/ 2.5gms	7.5gms/ 2.5gms
Appearance	amber	amber	amber	amber	amber	amber
Use Concentration (mls/ppm)	0.0 mls/ 0 ppm	0.04 mls/ 20 ppm	0.10 mls/ 50 ppm	0.20 mls/ 100 ppm	1.00 mls/ 500 ppm	2.00 mls/ 1000 ppm
E-coat Composition Deionized water/ e-coat waste	495 mls/ 5mls	495 mls/ 5mls	495 mls/ 5mls	495 mls/ 5mls	495 mls/ 5mls	495 mls/ 5mls
pH to 2.9	n/a	n/a	n/a	n/a	n/a	n/a
pH to 8.5	n/a	n/a	n/a	n/a	n/a	n/a
Floc size/appearance	tacky	tacky	tacky	tacky	hard floc/clear	spongy floc
Turbidity	58.5	49.9	48.2	34.1	14.8	32.9
Detackification 100 rpm:	bad 0%	bad 0%	bad 0%	bad 0%	good 0%	good 0%

TABLE 4

	#1	#2	#3	#4	#5	#6
Description	Preferred Embodiment 10+3+5+1+2	Preferred Embodiment 10+3+5+1+2	Preferred Embodiment 10+3+5+1+2	Preferred Embodiment 10+3+5+1+2	Preferred Embodiment 10+3+5+1+2	Preferred Embodiment 10+3+5+1+2
Product Dilution (Deionized water/product)	7.5gms/ 2.5gms	7.5gms/ 2.5gms	7.5gms/ 2.5gms	7.5gms/ 2.5gms	7.5gms/ 2.5gms	7.5gms/ 2.5gms
Appearance	amber	amber	amber	amber	amber	amber
Use Concentration (mls/ppm)	0.40 mls/ 200 ppm	0.60 mls/ 300 ppm	0.80 mls/ 400 ppm	1.00 mls/ 500 ppm	1.20 mls/ 600 ppm	1.40 mls/ 700 ppm
E-coat Composition Deionized water/ e-coat waste	495 mls/ 5mls	495 mls/ 5mls	495 mls/ 5mls	495 mls/ 5mls	495 mls/ 5mls	495 mls/ 5mls
pH to 2.9	n/a	n/a	n/a	n/a	n/a	n/a
pH to 8.5	n/a	n/a	n/a	n/a	n/a	n/a
Floc size/appearance	sl. tacky	sl. tacky	sl. tacky	fluffy	fluffy	fluffy
Turbidity	80.6	62.1	63.9	41.6	39.0	39.9
Detackification 50 rpm:	fair > 50%	good 95%	good 100%	good 100%	good 100%	good 100%

TABLE 5

Table 5 provides a comparative example of the testing of the preferred embodiment 3920-93, compared to the performance of the individual components thereof. Nos. 1 through 5 are demonstrative of the use of the individual component alone noted after the heading "Description".

5

TABLE 5

	3930-93	1	2	3	4	5
Description	Preferred Embodiment	40% FeCl ₃ sol.	50% MAP sol.	50% Al ₂ OH ₅ Cl sol.	30% CaCl ₂ sol.	50% CA-250 sol.
Product Dilution (Deionized water/product)	7.5gms/2.5gms	7.5gms/2.5gms	7.5gms/2.5gms	7.5gms/2.5gms	7.5gms/2.5gms	7.5gms/2.5gms
Appearance	med. amber	yellow	water white/clear	water white/clear	water white/clear	water white/clear
Use Concentration (mls/ppm)	0.60mls/300ppm	0.60mls/300ppm	0.60mls/300ppm	0.60mls/300ppm	0.60mls/300ppm	0.60mls/ppm
E-coat Composition Deionized water/e-coat waste	495 mls/5mls	495 mls/5mls	495 mls/5mls	495 mls/5mls	495 mls/5mls	495 mls/5mls
pH to 2.9	41 drops	38 drops	44 drops	46 drops	50 drops	50 drops
pH to 8.5	64 drops	64 drops	66 drops	68 drops	69 drops	70 drops
Floc size/appearance	lg.-vig./slight haze	extra lg./very hazy	lg./hazy	fine/very hazy	very fine/turbid	jelly/turbid
Turbidity	76	146	138	181	275	296
Detackification	good	bad	very bad	fair	none	none
50 rpm:	100%	0%	0%	20%	0%	0%
100 rpm:	100%	40%	20%	75%	0%	0%

TABLE 6

Table 6 demonstrates the effect of varying the volume composition of components of the preferred embodiment and the effect of the complete omission of the $\text{Al}_2\text{OH}_5\text{Cl}$ component. The ratios noted in this table utilize the concentrations of each component set forth above.

TABLE 6

	#1	#2	#3	#4	#5	#6
Description	FeCl ₃ +MAP	FeCl ₃ +MAP+ Al ₂ OH ₅ Cl	Fe ₃ +MAP+ Al ₂ OH ₅ Cl	Fe ₃ +MAP+ Al ₂ OH ₅ Cl	Fe ₃ +MAP+ Al ₂ OH ₅ Cl+ CaCl ₂	Fe ₃ +MAP+ Al ₂ OH ₅ Cl+ CaCl ₂ + CA-250
Ratio (mls)	10+3	10+3+5	15+3+5	10+3+10	10+3+5+1	10+3+5+1+2
Product Dilution Deionized water/product	7.5gms/ 2.5 gms	7.5gms/ 2.5 gms	7.5gms/ 2.5 gms	7.5gms/ 2.5 gms	7.5gms/ 2.5 gms	7.5gms/ 2.5 gms
Appearance	Yellow	Amber	Amber	Very dark amber	Amber	Amber
Use Concentration (mls/ppm)	0.60mls/ 300ppm	0.60mls/ 300ppm	0.60mls/ 300ppm	0.60mls/ 300ppm	0.60mls/ 300ppm	0.60mls/ ppm
E-coat Composition Deionized water/ e-coat waste	495 mls/ 5mls	495 mls/ 5mls	495 mls/ 5mls	495 mls/ 5mls	495 mls/ 5mls	495 mls/ 5mls
pH to 2.9	34 drops	38 drops	36 drops	40 drops	37 drops	37 drops
pH to 8.5	60 drops	61 drops	63 drops	64 drops	61 drops	62 drops
Floc size/appearance	lg. fluffy/hazy	lg. sl. fluffy/ very hazy	lg. fluffy/hazy	lg. fluffy/hazy	large/hazy	large/hazy
Turbidity	144	95	103	139	99.3	80
Detackification 50 rpm: 100 rpm:	very bad 0% 20%	good 75% 95%	fair 50% 75%	bad 20% 50%	good 100%	good 100%

TABLE 7

Table 7 sets forth the results of test performed utilizing various aluminum hydroxy chlorides as substitutes for $\text{Al}_2\text{HO}_5\text{Cl}$ in the preferred embodiment. These aluminum hydroxy chlorides are:

Aluminum hydroxy chloride	FORMULA	% BASICITY	% SOLIDS	% Al_2O_3
A Preferred Embodiment	$\text{Al}_2(\text{OH})_5\text{Cl}$	83	50	23.5
B	$\text{Al}_2(\text{OH})_3\text{Cl}_2(\text{SO}_4)_{0.5}$	50	30	10
C	$\text{Al}_2(\text{OH})_{1.8}\text{Cl}_{4.2}$	30	33	8
D	$\text{Al}_2(\text{OH})_3\text{Cl}_2(\text{SO}_4)_{0.5}$	70	50	15
E	$\text{Al}_2(\text{OH})_3\text{Cl}$	50	33	10
F	Ferrous Chloride (FeCl_2)	--	28	--
G	$\text{Al}_2(\text{OH})_2\text{Cl}_4$	30	40	--
H	$\text{Al}_2(\text{OH})_3\text{Cl}_3$	55	40	--
I	$\text{Al}_2(\text{OH})_3\text{SO}_4\text{SiO}_3$	-35	-35	--

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TABLE 7

Description	Preferred Embodiment	C	D	E	H	G	B	I	F
Product Dilution Deionized water/product	7.5gms/ 2.5gms	7.5gms/ 2.5gms	7.5gms/ 2.5gms	7.5gms/ 2.5gms	7.5gms/ 2.5gms	7.5gms/ 2.5gms	7.5gms/ 2.5gms	7.5gms/ 2.5gms	7.5gms/ 2.5gms
Appearance	lt. amber	lt. amber	lt. amber	yellow	yellow	yellow	yellow	yellow	yellow
Use Concentration (mls/ppm)	0.60mls/ 300ppm	0.60mls/ 300pp	0.60mls/ 300ppm	0.60mls/ 300ppm	0.60mls/ 300ppm	0.60mls/ 300ppm	0.60mls/ 300ppm	0.60mls/ 300ppm	0.60mls/ 300ppm
E-coat Composition Deionized water/ e-coat waste	495 mls/ 5mls	495 mls/ 5mls	495 mls/ 5mls	495 mls/ 5mls	495 mls/ 5mls	495 mls/ 5mls	495 mls/ 5mls	495 mls/ 5mls	495 mls/ 5mls
pH to 2.9	46 drops	37 drops	41 drops	38 drops	39 drops	39 drops	38 drops	38 drops	35 drops
pH to 8.5	105 drops	105 drops	131 drops	120 drops	106 drops	92 drops	100 drops	106 drops	106 drops
Floc size/ appearance	lg. fluffy/ clear	lg. fluffy/ sl. haze	lg. fluffy/ sl. haze	lg. fluffy/ sl. haze	lg. fluffy/ sl. haze	lg. fluffy/ sl. haze	lg. fluffy/ sl. haze	lg. fluffy/ sl. haze	lg. fluffy/ sl. haze
Turbidity	18.5	35.7	29.0	34.9	52.4	35.3	33.4	36.6	53.9
Detackification 50 rpm:	good 90%-95%	good 100%	good 90%	good 85-90%	fair-good 80-85%	fair-good 80-85%	fair-good 80-85%	good 85%	good 80-85%
100 rpm:	100%		100%	100%	100%	100%	100%	100%	100%

TABLE 8

Table 8 illustrates the performance of the preferred embodiment compared to the performance when substitutions of various components are made in the same volume and concentration. The second column shows the effect of the substitution of FeBr_3 for FeCl_3 . 4023-8A
5 4023-8C and 4023-8E show the results of the substitution of the noted phosphorous compound for MAP. 4023-13A and 4023-13A show the results of the substitution of the noted component for CaCl_2 .

TABLE 8

Description	Preferred Embodiment	FeBr ₃	NH ₄ HPO ₄	KH ₂ PO ₄	Na ₂ HPO ₄	MgCl ₂	BaCl ₂
Product Dilution Deionized water/product	7.5gms/ 2.5gms	7.5gms/ 2.5gms	7.5gms/ 2.5gms	7.5gms/ 2.5gms	7.5gms/ 2.5gms	7.5gms/ 2.5gms	7.5gms/ 2.5gms
Appearance	med. lt. amber	very lt. amber	reddish	dk. reddish	dk. reddish	med. lt. amber	med. lt. amber
Use Concentration (mls/ppm)	0.60mls/ 300ppm	0.60mls/ 300ppm	0.60mls/ 300ppm	0.60mls/ 300ppm	0.60mls/ 300ppm	0.60mls/ 300ppm	0.60mls/ 300ppm
E-coat Composition Deionized water/ e-coat waste	495 mls/ 5mls	495 mls/ 5mls	495 mls/ 5mls	495 mls/ 5mls	495 mls/ 5mls	495 mls/ 5mls	495 mls/ 5mls
pH to 2.9	38 drops	31 drops	42 drops	40 drops	49 drops	40 drops	48 drops
pH to 8.5	94 drops	28 drops	94 drops	103 drops	105 drops	92 drops	107 drops
Floc size/appearance	lg. fluffy/clear	lg. fluffy/ sl. cloudy	lg. fluffy/sl. haze	lg. fluffy/ hazy	lg. fluffy/ hazy	med. fluffy/ clear	med. fluffy/ hazy
Turbidity	30	70	23.8	29.3	34.6	28.8	40.1
Detackification 50 rpm: 100 rpm:	good 80% 100%	good 85% 99%	good 90% 100%	fair 50% 100%	fair 75% 100%	good 90% 100%	fair-good 80% 100%